

Date: Monday, 2/27/2006 4:22:22 PM
User: Kim Johnston

Process Sheet

SPLIT

| | |
|---|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : LUG |
| Job Number : 26002 A | |
| Estimate Number : 10008 | |
| P.O. Number : N/A | Part Number : D2591 |
| This Issue : 2/27/2006 S.O. No. : N/A | Drawing Number : D2591 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : D |
| Previous Run : 25863 | Material : N/A |
| Written By : SEE COMMENT BELOW | Due Date : 3/15/2006 |
| Checked & Approved By : JF 06.02.28 | Qty: 18 Um: 40 Each |
| Comment : Est Rev:I Removed from 9 Digit 05-10-25 JLM | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------------------|--------------------------|
| 1.0 | M1010B0750X02500 | ASTM A21 Steel .75"x2.5" |
|-----|------------------|--------------------------|



Comment: Qty.: 0.2340 f(s)/Unit Total: 9.3600 f(s)
ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
Batch: M19492 - 18

JF 06/03/02

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
Cut blanks: 2.700" long

JF 06/03/02 18

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio FA 039 and Dwg D2591
2-Deburr if required

JF 06/03/02 18

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JF 06/03/02 18

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

J.G. 06/03/02 18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/03/06
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26002

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5751

6 4/3/3 (18)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/03/06 (18)

Job Completion



U 06-03-03

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng./ Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

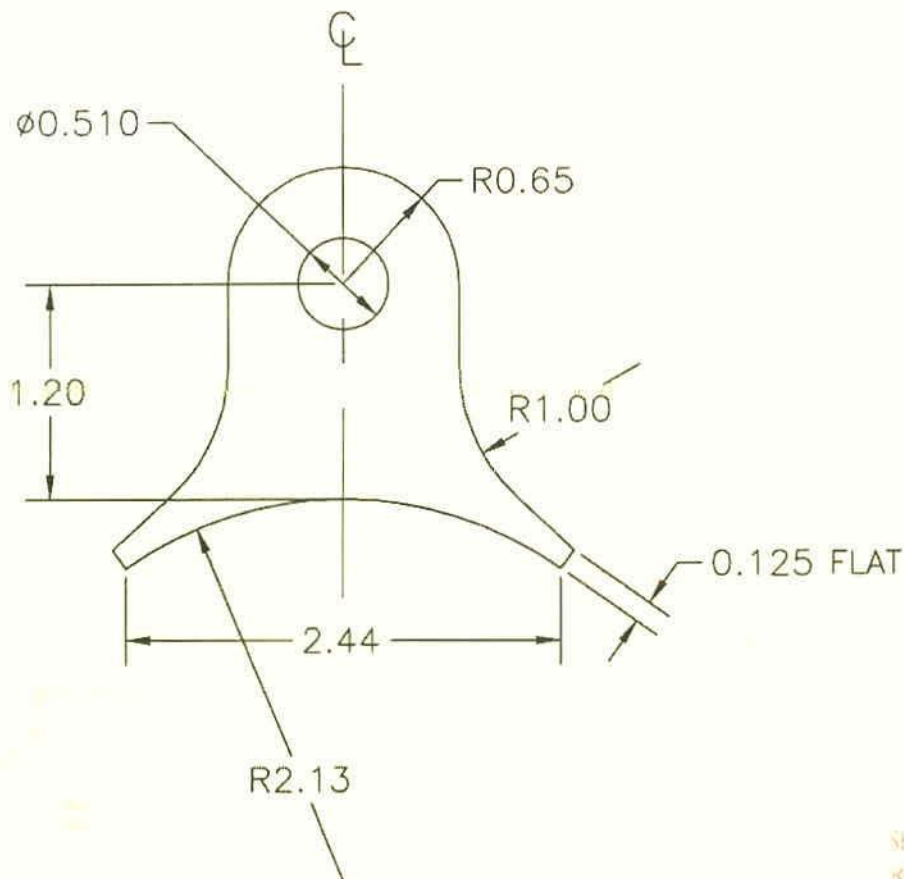
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------------------|-----------------------|--|------------------------|
| DESIGN <i>ME</i> | DRAWN BY <i>ME</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>KE</i> | APPROVED <i>BW</i> | DRAWING NO. D2591 | REV. D SHEET 1 OF 1 |
| DATE 98.01.21 | | TITLE GHW LUG | SCALE 1:1 |
| A | 96:09:16 | NEW ISSUE | |
| B | 97:06:17 | RE-DESIGN TO FLAT BOTTOM | |
| C | 97.12.12 | RE-DESIGN TO RADIUS BOTTOM | |
| D | 98.01.21 | 0.125 FLAT WAS 0.067 FLAT | |

RELEASED
98.01.21 DS

BREAK ALL SHARP CORNERS ~~0.010~~ TO 0.020
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26002

